

SHIP Dec 10

Dart Aerospace Ltd.

Date:
User:Tuesday, 11/21/2006 1:15:42 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 29606		
Estimate Number	: 11683		
P.O. Number	: N/A	Part Number	: D2888
This Issue	: 11/21/2006 S.O. No. : N/A	Drawing Number	: D2888 REV A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>061121</u>	Due Date	: 12/10/2006
Checked & Approved By	: <u>061121</u>	Qty:	28 Um: Each
Comment	: Est. C 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B2500X03500 6061-T6 Bar 2.5" x 3.5"



Comment: Qty.: 0.3938 f(s)/Unit Total: 11.0250 f(s)
6061-T6 Bar 2.5" x 3.5"
Material: 3.5" x 2.5" bar 6061-T6

M14805/1PCS J.F. 06/11/28
Batch M19059/29PCS (30)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks 4.20" long
(Grain along 4.20")

J.F. 06/11/28 (30)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per folio D2888
Deburr and Tumble

J.F. 06/11/28 (28)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/11/28 (28)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

Y.F. 06/11/30 X 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DA Date: 06/12/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/29	3	2 pieces are scrapp The Dimension 1,000" is to wide on the first one. per on the second one the dimension 1,375" is to short.	CP 06.12.08 per 051042	scrap and replace.	JF. 06/11/29	DA 06/11/30	CP 06.12.08 per 051042	DA 06/11/30

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:15:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 29606

Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

11/06/12/05

(28)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FCY

06/12/06 X 28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LB 06/12/07 (28)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST326

LB 06/12/07 (28)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/08

Job Completion



U 06/12/08

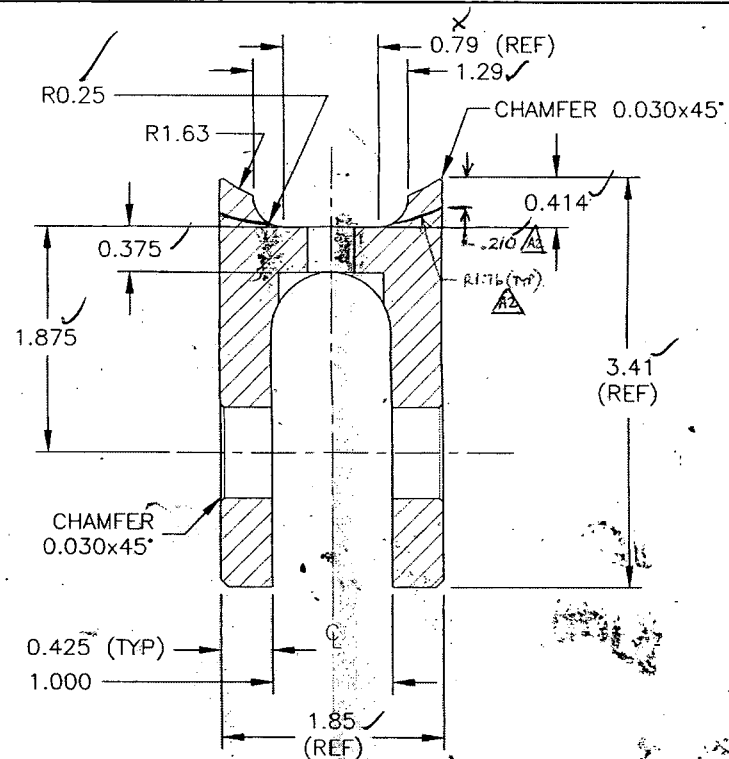
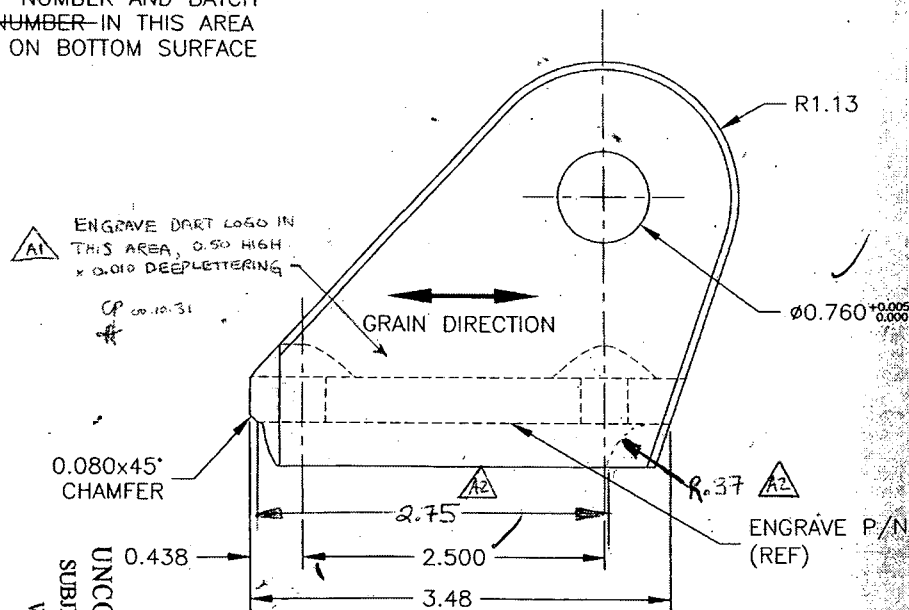
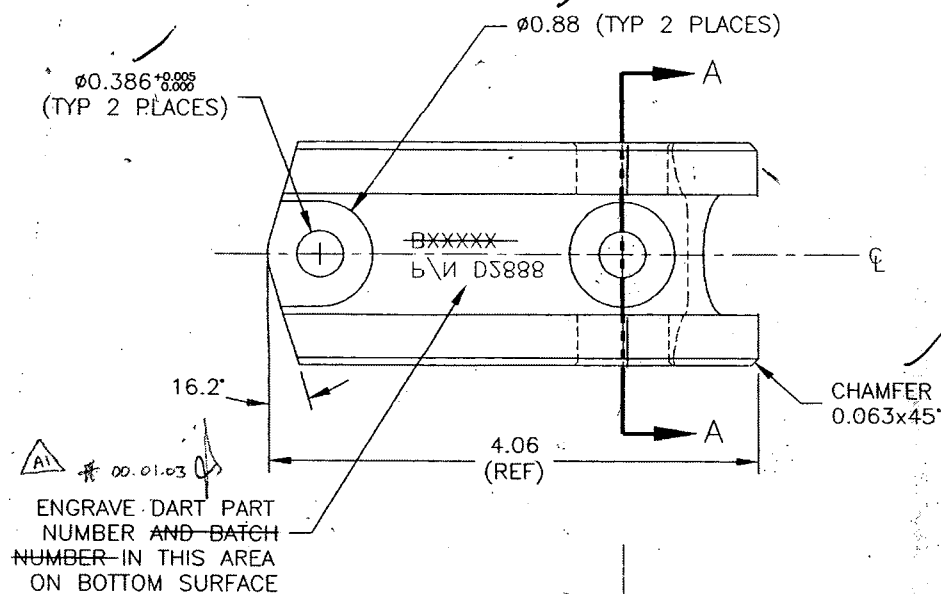
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	*By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NCR 754	99.06.21	NEW ISSUE	DART	DART AEROSPACE LTD 3 HAWKESBURY, ONTARIO, CANADA	REV. A
A1	00.10.31	Update Engraving	99.06.21		D2888		SHEET 1 OF 1
					LUG		SCALE 1:1

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NO. 24606
WORK ORDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Φ.386	+ .006 - .001	.390	✓			
Φ.88	+ - .030	.880	✓			
.063x45°	+ - .010	.058x45°	✓			
4.06	+ - .030	4.057	✓			
Φ.760	+ .005 - 0	.763	✓			
2.500	+ .010 - .010	2.500	✓			
3.48	+ .030 - .030	3.490	✓			
.438	+ .010 - .010	.438	✓			
.08x45°	+ .010 - .010	.08x45°	✓			
1.85	+ .030 - .030	1.849	✓			
1.000	+ .010 - .010	1.007	✓			
.425	+ .010 - .010	.420	✓			
1.875	+ .010 - .010	1.885	✓			
.375	"	.381	✓			
1.29	+ .030 - .030	1.289	✓			
.414	+ .010 - .010	.412	✓			
.210	+ .010 - .010	.214	✓			
3.410	+ .030 - .030	3.415	✓			
5.25	"	.250	✓			
.03x45°	+ .010 - .010	.030x45°	✓			
5.37	+ .030 - .030	.375	✓			

Measured by:	J.L
Date:	06/11/26

Audited by:	9m2
Date:	06/11/25

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	